

ENGINEERING CHANGE NOTICE
DART AEROSPACE LTD

mpp

Date: 19.03.07	Job No.: RB18-BELL	ADR Yes/No: N	ADR Date:	ECN #: 19- 572
Product No.: DART TOOLING BELL		Created By: VM	Approved By: VK	
Product Name: JET RANGER FIELD KIT		Checked By: mpp		

Reason for Change:
ITEMS MISSING

Documents Released:

RBT18510 REV L

IF APPLICABLE: NCR: _____ PAR: _____ CAR: _____ CIR: _____ URF: 19-572

PAPERWORK UPDATE

PARTS MUST COMPLY

PREVIOUS PARTS SATISFACTORY

#	Quality Assurance / Customer Support Actions	Reqd	Resp	Notes	Complete
1	Notify Previous Customers	N			
2	Notify Airbus	N			
3	Notify Leonardo	N			
4	Manufacturing Licensing Agreement Update	N			

#	Engineering Actions	Reqd	Resp	Notes	Complete
5	Required Documents/Drawings/Item ID's Under Review (URF)	N			
6	Update Master Document List (MDL)	N			
7	Update Document Record (DR)	N			
8	Update Product Compatiability Matrix	N			
9	Notify TC / FAA of Change (eg. ICA, 8110-3)	N			
10		N			

#	Document Control Actions	Reqd	Resp	Notes	Complete
11	Move / Update Electronic Files / Design Journal	Y	MD		Urgent 19.03.07
12	Update Product Specification Files (Bluefiles)	N			
13	Update Approved/Preliminary Dwg PDF Files	Y	MD		Urgent 19.03.07
14	Update Product Development Summary (STC applications)	N			
15	Update QSI 021 (TC/FAA STC) and/or STC Approval List	N			
16	Create/Update Parts / STC Database	Y	MD		Urgent 19.03.07
17	Update / Verify Authorized Release Certificate Database	Y	MD		Urgent 19.03.07
18	Create / Update Change Record Form / Item Card Database	Y	MD		Urgent 19.03.07
19	Create / Update Packaging Process Plan (PPP)	N			
20	Red Decals required on Packaging Process Plan (PPP)?	N			
21	Update Controlled Supplier Documents (Opulse) Database	N			
22	Update Grey Project Binder / Electronic Project Folder	N			
23	Update D-Part / M-Drawing / DS1 / DEO Master Binders	N			
24	Update "Royalty Paid to" attribute (Parts sold under Dart USA STC's)	N			
25					

Description / Action:

CLOSE URF 19-572

STOCK NEED TO BE RE-WORK PER REV L (see drawing for more info)

RELEASE RBT18510 REV L DRAWING

PLACE DRAWING RBT18510 REV 10 IN SUPERCEED FOLDER

3STK QRTN

S02800D
S123722

S123723

-2
-3
-5
-6

N/A APP-5M3202C?
see
stamped
in 20.03.03

ECN Verified & Complete: _____

Date: _____



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

ORDER ACKNOWLEDGEMENT

CUSTOMER

Customer Code: CHPAN01

Sold To: Helicopteres Panorama Ltee
360 Chemin De L'Aeroport
Alma QC G8B 5V2
Canada
Phone: 418 668 0761

Ship To: Happy Gas INC
#102-11010 Airport Drive, Hangar 1
Grand Prairie AB T8V 7Z5
Canada

ORDER

Order No : 13503

Date: 2/8/19

Ship-To Contact: Normand Cote

Email: ncote@panoramahelico.com

Cust PO No: 3751

FOB: Shipping Point

Ship Via:

Freight Terms: PrePaid

Terms: Net 30

INCO Terms: Ex Works

Order Taker: Caitlin Crooks

Order Taker Phone:

Order Taker Email: ccrooks@dartaero.com

Line No	Due Date	Ship Date	Part	Description/Note	Quantity	Unit	Price	Unit	Extended Price	
1	2/22/19	2/22/19	D205-634-011	Skidtube with Standard Wearplates Fits LH or RH	1	pcs	\$6,210.00	USD	PCS	\$6,210.00 USD
				12% Discount Diamond			-12.00			-\$745.20
									Sub Total	\$5,464.80
									Tax	\$710.42
									Sub Total	\$6,175.22 USD
									Grand Total	\$6,175.22 USD

ORDER NOTES

Day And Ross ACCT#148127

RBT18S10 x2 min
Others sold?

Rework ship
25/2/18

Remit to: DART Aerospace Ltd., 1270 Aberdeen Street, Hawkesbury, Ontario K6A 1K7 Canada

Tel: 613 632 5200

Fax: 613 632 5246

accounting@dartaero.com

GST/HST 10127 2607

Note: A minimum 15% restocking fee is applicable. Custom items are non-refundable. Full warranty details are available at www.dartaerospace.com

International / US Wires:

Swift Code: CHASUS33 Bank Routing #: 021000021 Account #: 133281000

Bank Name: JPMorgan Chase Bank 201 St. Charles Ave., New Orleans, LA USA 70170

Account Name: DART Aerospace Ltd.

Notification October 2018: Our banking information has remained unchanged

Post offices
does not allow
job costum
19.02.26

Under Review Notification

Raised By: Ketan Tailor

Date: February 12, 2019

Product #: Dart Tooling Bell

Product Name: Jet Ranger Field Kit

Description of Issue:

Need to add foam inside of pelican case to protect tools on top. Use item -81 from REV. 8A (as per deviation)

3 in QRTN
5028081
S123722

Distribution:

VP Operations

Director of Operations

Director Quality Assurance

QC Coordinator

Director of Engineering

Chief Engineer

Engineering Project Managers

Engineering Project

Customer Support Manager

Production Engineers

Production Planning

Purchasing Manager

Technical Support

Product Manager - Solutions Provider

Supply Chain Director / Senior Buyer

Supply Chain Business
Marketing Eugene

H:\Forms\Engineering\Approved ENG Online\IRF revE.xls



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

ORDER ACKNOWLEDGEMENT

CUSTOMER

Customer Code: CBGHE01

Sold To: BGHelicopters

Heliport Circuit de Barcelona
08160 Montmeló
Catalunya
Spain
Phone: +34 935 167 044

Ship To: BGHelicopters

Heliport Circuit de Barcelona
08160 Montmeló
Catalunya
Spain
Phone: +34 935 167 044

ORDER

Order No : 13240

Date: 2/1/19

Ship-To Contact: David Iturbide

Email: david@bghelicopters.com

Cust PO No: 001-19BGH

FOB: Shipping Point

Ship Via: See comments below

Freight Terms: Third Party Billing

Terms: Prepay

INCO Terms: Ex Works

Order Taker: Kinga Lysiak

Order Taker Phone:

Order Taker Email: klysiak@dartaero.com

Line No	Due Date	Ship Date	Part	Description/Note	Quantity	Unit	Price	Unit	Extended Price
1	3/7/19	3/7/19	RBT18510p	Bell 206A/B Field Maintenance	1	pcs	\$9,955.00USD	pcs	\$9,955.00 USD
				Special Discount			-10.00		\$-995.50
								Sub Total	\$8,959.50 USD
								Grand Total	\$8,959.50 USD

ORDER NOTES

RA570 applies to this order

FEDEX account N° 995998556, and please choose economy

Custom Clearance To Be Billed To Receiver

Duties & Taxes To Be Billed To Receiver

Ship Order As Soon As Possible

Use Discounted Price On Shipping Documents

10011097

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

Route update only

Job: _____		DISPOSITION	DEPARTMENT/PROCESS					
Part No. RBT18510 Rev. 10		Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Large Fab <input type="checkbox"/>	Cross tube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/>	Eng. (Non-AW) <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/>	Engineering <input type="checkbox"/> Water Jet <input type="checkbox"/> Supplier Quality <input type="checkbox"/>		
Date :	Sequence #:	QTY Affected :			MRB (OSI042) <i>MLee</i> Feb 5, 2019			
Description Work Order Deviation		Disposition						
Kuri-Tech Hose (K010-0608) easily pulls out of Coupling (McMaster Carr 51495K116) *sub component of kit*		Install a 1.0" long, 0.38" OD, 0.25" ID piece of Stainless Steel into one end of the Kuri-Tech Hose until flush. Attach the modified end of the Kuri-Tech Hose to the Coupling before placing tool into packaging (if applicable).						
ADD ITEM -81 (FOAM LID) FROM REV. 8A Hot glue the foam lid into the pelican case to protect the tools in the top foam. <u>Foam lid</u> must be made per RBT18510-81 REV. 8A. STEP file. Foam lid to be made with Black Ethafoam 220 or EQUIV.		This deviation is acceptable. The fit, form and function of the part will be as originally intended.						
Root Cause		FAULT CATEGORY						
Operator <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/> Bending <input type="checkbox"/> Crushing <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Mislabelled <input type="checkbox"/>	Contamination <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Incomplete/Unclear Instructions <input type="checkbox"/> Drill Holes <input type="checkbox"/> Fit/Function <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain Direction <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Off-set/Set-up <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/> Outside Tolerance <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Misread <input type="checkbox"/>				
Manufacturing Process <input type="checkbox"/>								
Equip/Tooling <input type="checkbox"/>								
Handling/Preservation <input type="checkbox"/>								
Material <input type="checkbox"/>								
Product Improvement <input checked="" type="checkbox"/>								
Process Improvement <input type="checkbox"/>								
Human Factors <input type="checkbox"/>								
		Other/Details:						

Linda Lacelle

From: qpulse@dartaero.com
Sent: Friday, February 8, 2019 12:02 PM
To: Patrick Smith; Linda Lacelle
Subject: Action added to Non Conformance
Attachments: Locate Record.qpulse

Details: An action has been added to the following Non Conformance;

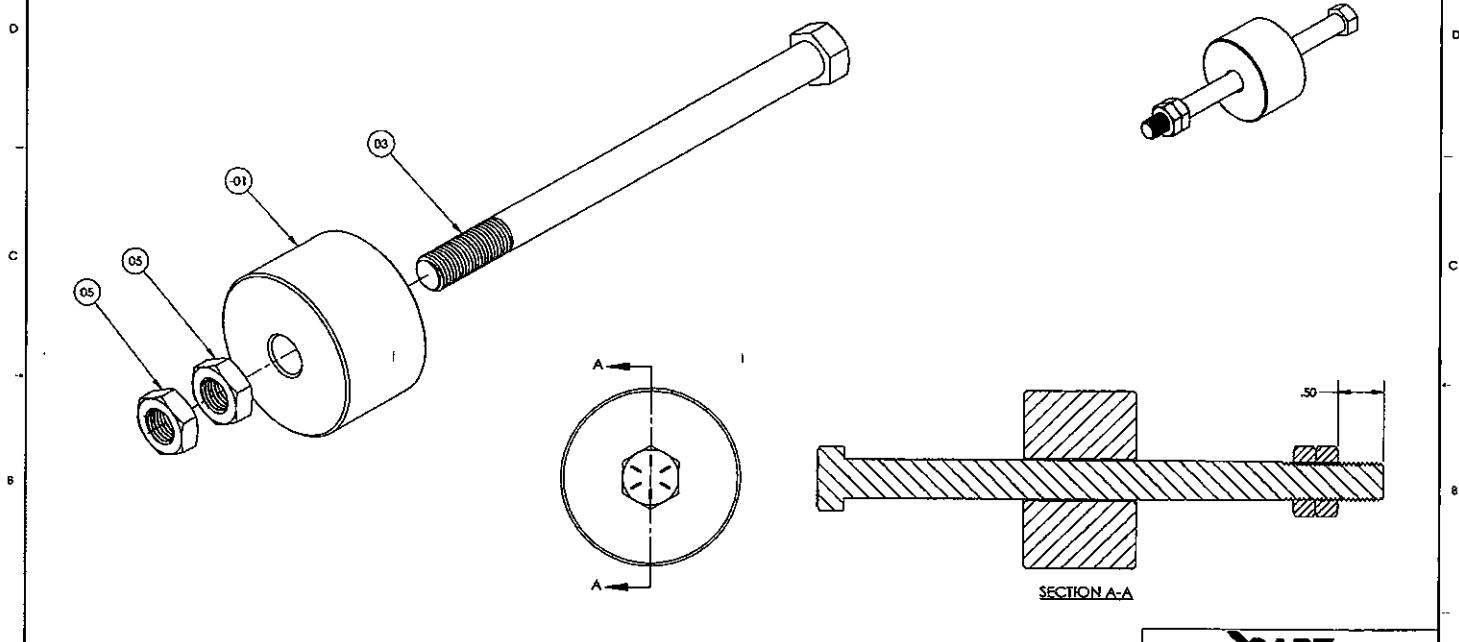
Number	NCR19-7061
Report	Non-Conformance Report
Process	Employee finding

Details	Raised by customer support - Kit Part# RBT18561; RBE2-10-1 sub part has been damaged by the rivets in the top portion of pelican case. Its is also corroded. Found issue when inspecting RA570
---------	--

Owner	Lee, Mike
Target Date	

Type	Corrective Action
Number	3
Owner	Lacelle, Linda
Details	Re-work kits in quarantine- damaged part# RBE2-10-1 as soon as possible

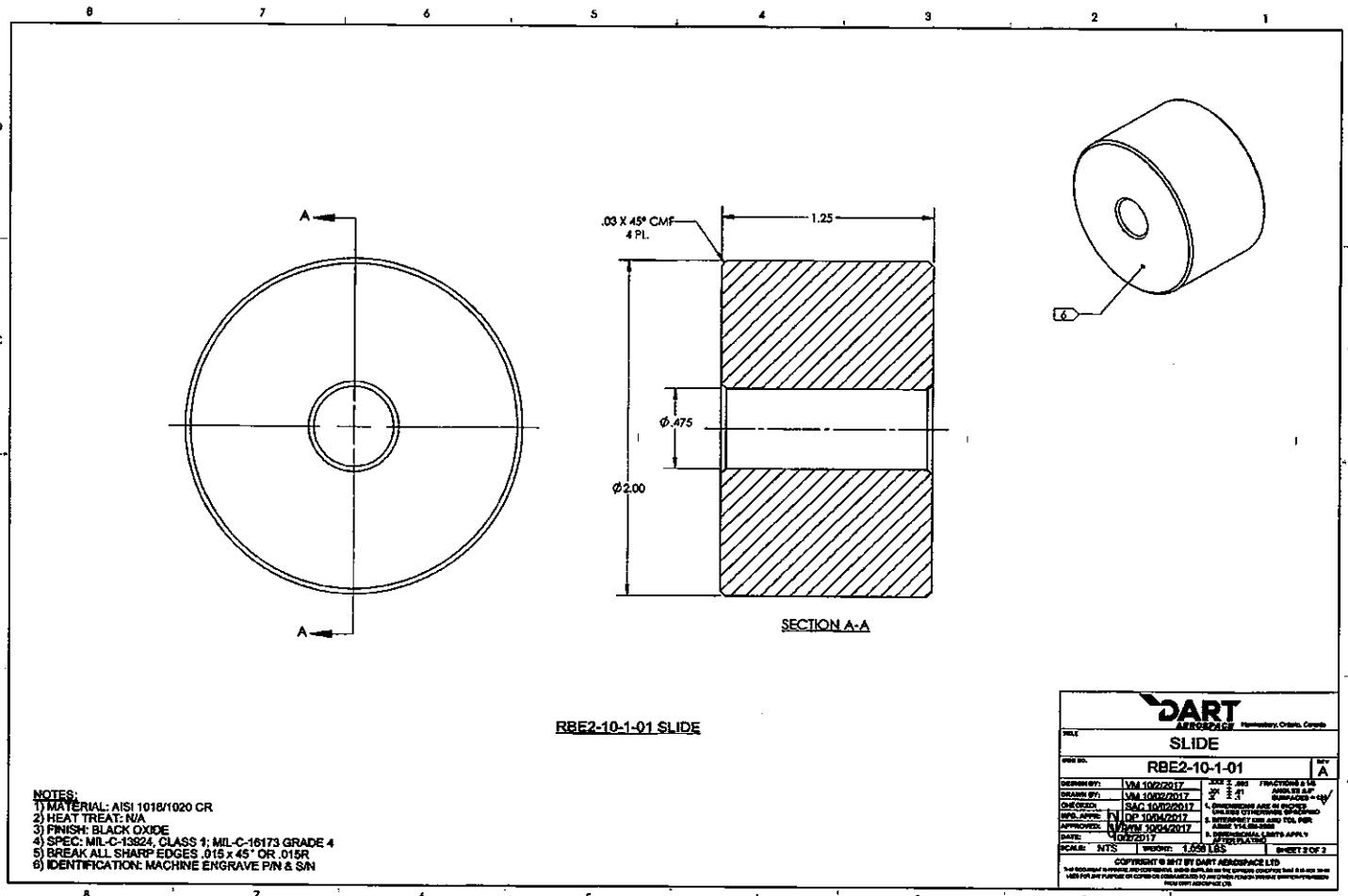
ITEM #	QTY	PART #	TITLE	PG	REV.	DESCRIPTION	ECN #	DATE	BY	APPROVED
-01	1	RBE2-10-01	SLIDE	2	A	NEW ISSUE	17-688	17-10-02	VM	WM
03	1	McMaster#91257A481	HEX HEAD SCREW 7/16"-20 x 6" LG.	-						
05	2	McMaster#93839A820	THIN HEX NUT 7/16"-20	-						



RBE2-10-1 FUEL SYSTEM CARTRIDGE REMOVAL TOOL

NOTES:
 1) MATERIAL: N/A
 2) HEAT TREAT: N/A
 3) FINISH: N/A
 4) SPEC: N/A
 5) BREAK ALL SHARP EDGES: N/A
 6) IDENTIFICATION: N/A

RBE2-10-1	
FUEL SYSTEM CARTRIDGE REMOVAL TOOL	
DESIGN NO.	REV. A
DRAWN BY: VMA102/2017	JOE S. JAHN FRACTIONAL 2 1/2
RECHECKED BY: VMA102/2017	ANGLES 8.7°
CHECKED BY: SAC 100/2017	3° ± 1°
APPROVED BY: DDP 100/2017	1. DIMENSIONS ARE IN INCHES 2. INTERFERENT DIM AND TOE PER 3. DRAWING IS FOR INFORMATION ONLY 4. THIS DRAWING IS THE PROPERTY OF DART AEROSPACE LTD 5. DIMENSIONAL LIMITS APPLY 6. AFTER PLATES
DATE: 10/04/2017	SECTION 1 OF 2
SCALE: NTS	WEIGHT: N/A
COPYRIGHT © 2017 BY DART AEROSPACE LTD	
THIS DRAWING IS THE PROPERTY OF DART AEROSPACE LTD AND IS FOR INFORMATION ONLY. IT IS NOT TO BE COPIED OR DISSEMINATED WITHOUT THE EXPRESS WRITTEN APPROVAL OF DART AEROSPACE LTD.	



RBE2-10-1-01		A
REV	SLIDE	
RBE2-10-1-01		
DESIGN REV:	VM 1002/2017	DOC 2. JRS FRACTIONAL & MM
DRAWN BY:	VM 1002/2017	MM 2.41 1.000 IN 25.4MM
CHIEF DESIGNER:	SAC 1004/2017	1. DIMENSIONS ARE IN INCHES
APPROVED:	OP 1004/2017	2. UNLESS OTHERWISE SPECIFIED
APPROVED:	VM 1004/2017	3. DIFFERENT FROM AND TO, PER
SCALE:	NTS	4. DIMENSIONAL LIMITS APPLY
WEIGHT:	1.650 LBS	5. DIMENSIONAL LIMITS
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THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL. UNAUTHORIZED USE OR DISSEMINATION IS PROHIBITED.		

Linda Lacelle

From: Ketan Tailor
Sent: Tuesday, February 26, 2019 11:21 AM
To: Linda Lacelle; Vanessa Morel
Cc: Chantal Lavoie; Daniel Paquette; David Duval; Michael Lee; Mychel Beauregard; Patrick Duval; Praduman Khayargoli; Steven Drouin
Subject: RE: URF 19-572 (RBT18510)
Attachments: RBE2-10-1-RevA.pdf

Hey Linda,

RBE2-10-1 was damaged due to the missing top foam. So we will have to manufacture another one at Rev. A to replace it.

Thanks,
Ketan

From: Linda Lacelle <llacelle@dartaero.com>
Sent: February-25-19 2:41 PM
To: Vanessa Morel <vmorel@dartaero.com>
Cc: Ketan Tailor <ktailor@dartaero.com>; Chantal Lavoie <clavoie@dartaero.com>; Daniel Paquette <dpaquette@dartaero.com>; David Duval <dduval@dartaero.com>; Michael Lee <mlee1@dartaero.com>; Mychel Beauregard <mbeauregard@dartaero.com>; Patrick Duval <pduval@dartaero.com>; Praduman Khayargoli <pkhayargoli@dartaero.com>; Steven Drouin <sdrouin@dartaero.com>
Subject: RE: URF 19-572 (RBT18510)

Understood, but what about the RBE2-10-1's? svp?

From: Vanessa Morel <vmorel@dartaero.com>
Sent: Monday, February 25, 2019 2:36 PM
To: Linda Lacelle <llacelle@dartaero.com>
Cc: Ketan Tailor <ktailor@dartaero.com>; Chantal Lavoie <clavoie@dartaero.com>; Daniel Paquette <dpaquette@dartaero.com>; David Duval <dduval@dartaero.com>; Michael Lee <mlee1@dartaero.com>; Mychel Beauregard <mbeauregard@dartaero.com>; Patrick Duval <pduval@dartaero.com>; Praduman Khayargoli <pkhayargoli@dartaero.com>; Steven Drouin <sdrouin@dartaero.com>
Subject: Re: URF 19-572 (RBT18510)

Hi Linda,

You can proceed with the deviation for the current order. All stock need to be rework per deviation. A top foam need to be added. The drawing will be update soon.

If you have any questions let me know,

Vanessa

Envoyé de mon iPhone

Le 25 févr. 2019 à 14:10, Linda Lacelle <llacelle@dartaero.com> a écrit :

All,

I know there is a URF for this, and a deviation, but still have not seen any ECN ? Also, I am about to make the rework orders, but am unsure of what needs to be done, besides changing out the foam. I see from below the RBE2-10-1's need to be reworked...what needs to be done to them pls??

<image001.png>

From: Ketan Tailor <ktailor@dartaero.com>

Sent: Tuesday, February 12, 2019 10:52 AM

To: Chantal Lavoie <clavoie@dartaero.com>; Daniel Paquette <dpaquette@dartaero.com>; Dart Sales <DartSales@dartaero.com>; David Duval <dduval@dartaero.com>; Frederick Leblanc <fleblanc@dartaero.com>; Jean Francois Cadieux <jcadieux@dartaero.com>; Jean Francois Sauve <jfsauve@dartaero.com>; Jean-Luc Menard <jmenard@dartaero.com>; John Chuprun <jchuprun@dartaero.com>; Ketan Tailor <ktailor@dartaero.com>; Konrad Sauve <ksauve@dartaero.com>; Linda Lacelle <llacelle@dartaero.com>; Marcel Daviau <mdaviau@dartaero.com>; Marie Lajeunesse <mlajeunesse@dartaero.com>; Michael Lee <mlee1@dartaero.com>; Michelle GagnonDonovan <mgagnondonovan@dartaero.com>; Mychel Beauregard <mbeauregard@dartaero.com>; Patrick Duval <pduval@dartaero.com>; Praduman Khayargoli <pkhayargoli@dartaero.com>; Regis Quenneville <rquenneville@dartaero.com>; Robert Aboud <raboud@dartaero.com>; Ross Black <rblack@dartaero.com>; Ryan Williamson <rwilliamson@dartaero.com>; Steven Drouin <sdrouin@dartaero.com>; Steven Hemmerich <shemmerich@dartaero.com>; Support Eugene <support.or@dartaero.com>; Support Hawkesbury <support.on@dartaero.com>; Vanessa Morel <vmorel@dartaero.com>

Subject: URF 19-572 (RBT18510)

Hey Everyone,

Please find the attached URF.

Linda Lacelle

From: Michelle GagnonDonovan <mgagnondonovan@dartaero.com>
Sent: Thursday, March 7, 2019 2:38 PM
To: Daniel Paquette; David Duval; Eric Lalande; Jean Francois Sauve; Jean-Luc Menard; Jennifer Renwick; Jesse White; John Chuprun; Linda Lacelle; Lisa McMachen; Marc Bellavance; Marcel Daviau; Marie Lajeunesse; Patrick Duval; Robert Aboud; Ross Black; Sian Willems; Steven Drouin; Steven Hemmerich; Support Eugene; Support Hawkesbury
Subject: REVISED: ECN 19-572
Attachments: ECN19-572.pdf

Hello All,

Please find revision to ECN 19-572 attached. Part disposition has changed from "Parts must comply" to "Previous Parts Satisfactory". See Rework instructions in bottom block of form.

Thank you,

Michelle Gagnon-Donovan

Document Control

DART AEROSPACE

T 1 613 632-5300 > 251

www.dartaerospace.com



From: Michelle GagnonDonovan

Sent: Thursday, March 07, 2019 1:36 PM

To: Daniel Paquette <dpaquette@dartaero.com>; David Duval <dduval@dartaero.com>; Eric Lalande <elalande@dartaero.com>; Jean Francois Sauve <jfsauve@dartaero.com>; Jean-Luc Menard <jmenard@dartaero.com>; Jennifer Renwick <jrenwick@dartaero.com>; Jesse White <jwhite@dartaero.com>; John Chuprun <jchuprun@dartaero.com>; Linda Lacelle <llacelle@dartaero.com>; Lisa McMachen <lmcmachen@dartaero.com>; Marc Bellavance <mbellavance@dartaero.com>; Marcel Daviau <mdaviau@dartaero.com>; Marie Lajeunesse <mlajeunesse@dartaero.com>; Patrick Duval <pduval@dartaero.com>; Robert Aboud <raboud@dartaero.com>; Ross Black <rblack@dartaero.com>; Sian Willems <sويليمز@dartaero.com>; Steven Drouin <ssdrouin@dartaero.com>; Steven Hemmerich <shemmerich@dartaero.com>; Support Eugene <support.or@dartaero.com>; Support Hawkesbury <support.on@dartaero.com>

Subject: ECN 19-572

Hello,

Please find a copy of ECN 19-572 attached.

Thank you,

Michelle Gagnon-Donovan

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DART AEROSPACE

T 1 613 632-5300 > 251

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